

Date: Thursday, 9/6/2007 8:50:29 AM
 User: Kim Johnston









Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR ADAPTER
Job Number : 34439	
Estimate Number : 12177	
P.O. Number : <i>N/A</i>	Part Number : D3476041
This Issue : 9/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3476 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34068	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/13/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3476043	blower motor adapter weldment
<div><div></div><div></div></div>		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	D3476-043	ADAPTER WELDMENT
		Batch B34441 B34440
<div>X<div>mf.</div></div>		
2.0	D34765	spacer ring
<div><div></div><div></div></div>		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	D3476-5	Ring
		Batch B 26619
<div>mf 07-09-06</div>		
3.0	AN34A	Bolt
<div><div></div><div></div></div>		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty	Part Number	Description
4	AN3-4A	Bolt
		Batch M103287
<div>mf 07-09-06</div>		
4.0	AN96010	Washer
<div><div></div><div></div></div>		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty	Part Number	Description
4	AN960-10	Washer
		Batch M5519
<div>mf 07-09-06</div>		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/6/2007 8:50:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 34439

Part Number: D3476041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3476

mf 07-09-06

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



(P40) →

Comment: INSPECT WORK TO CURRENT STEP

mf 07-09-06

①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: 6A

mf 07-09-11

8.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

mf 07-09-11

Job Completion

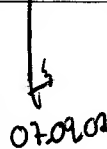
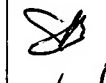




mf 07-09-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

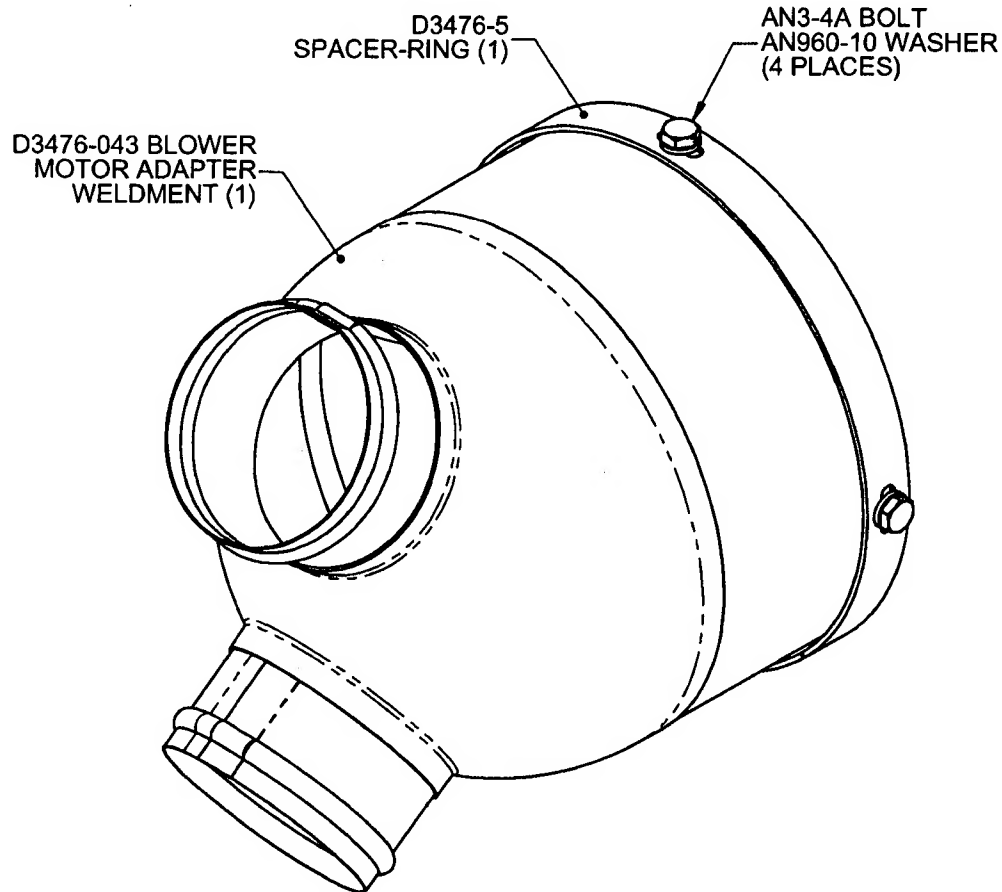
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/09/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/07	5.0	on D34767 (tube) only p st. lcs out by 1.58" should be 1.62".	 07/09/07	Acceptable	 07/09/07	En 07/09/07		 07/09/07

NOTE: Date & initial all entries

DART

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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2
A	06.01.27	NEW ISSUE	

[Signature] 06.04.03**D3476-041 BLOWER MOTOR ADAPTER**

1) IDENTIFY WITH DART P/N D3476-041 USING
FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

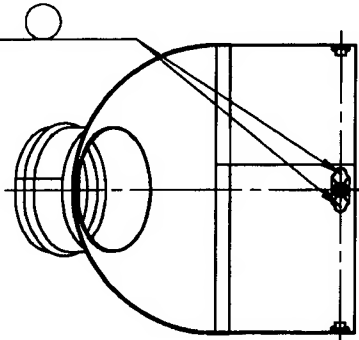
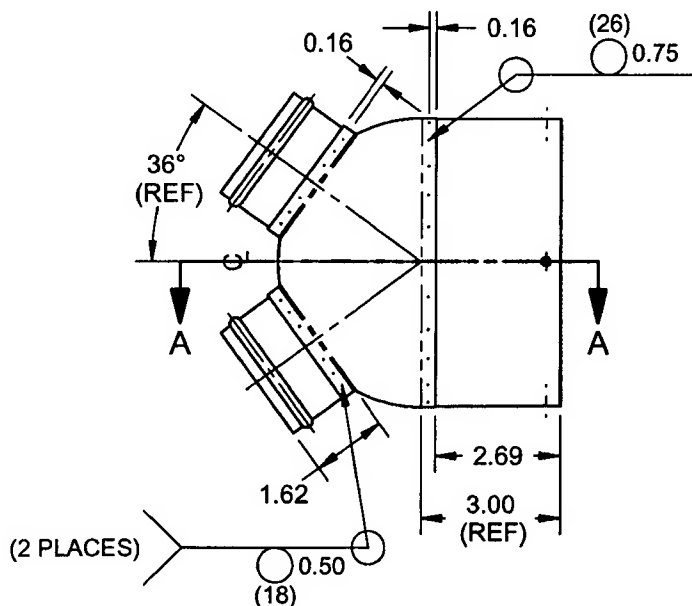
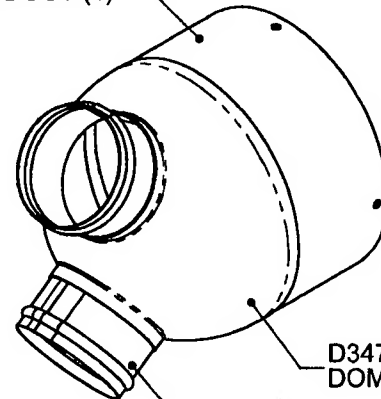
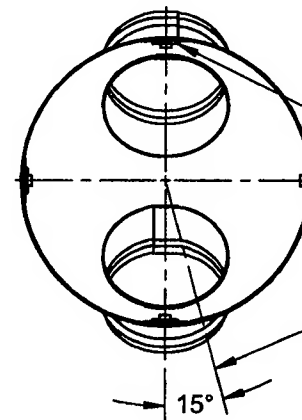
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NO. *34439*

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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)**SECTION A-A**D3476-1
DUCT (1)D3476-3
DOME (1)D3476-7 TUBE
(2 PLACES)NAS-1031C3W
NUT PLATES
(4 PLACES)OFFSET SEAM
ON DUCT

15°

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WORK ORDER
34439**D3476-043 BLOWER MOTOR
ADAPTER WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

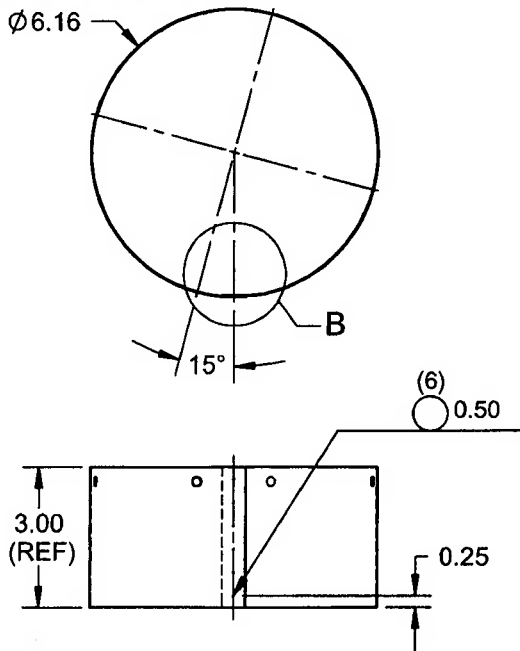
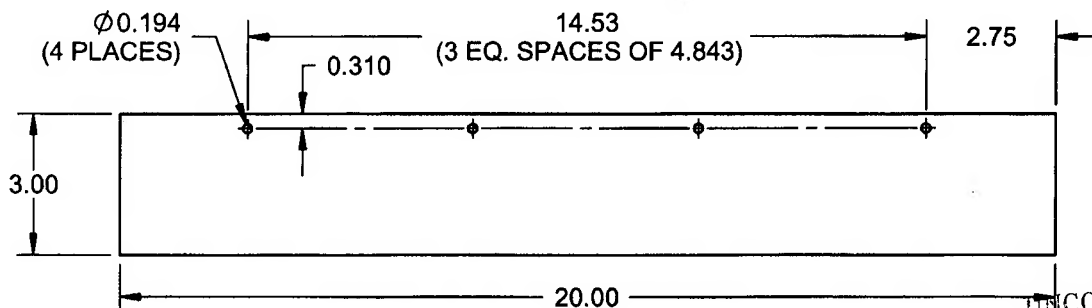
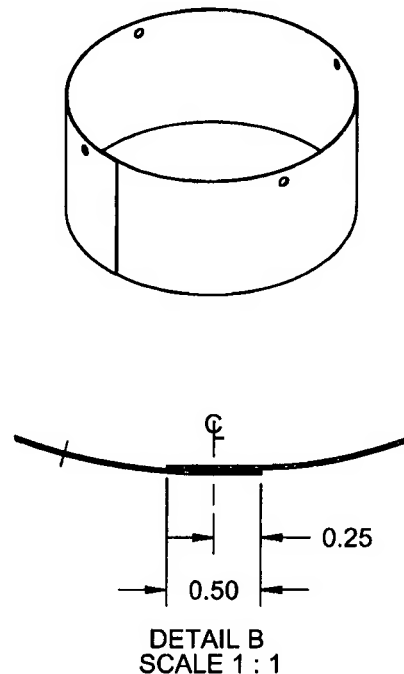
QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

[Signature] 06.04.03**D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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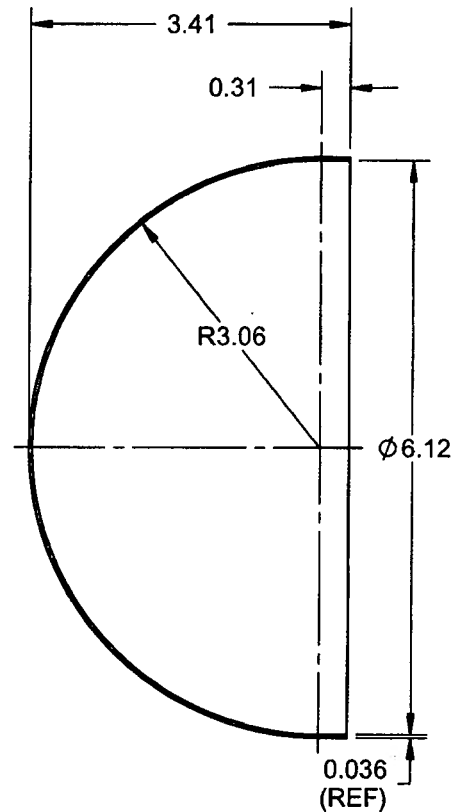
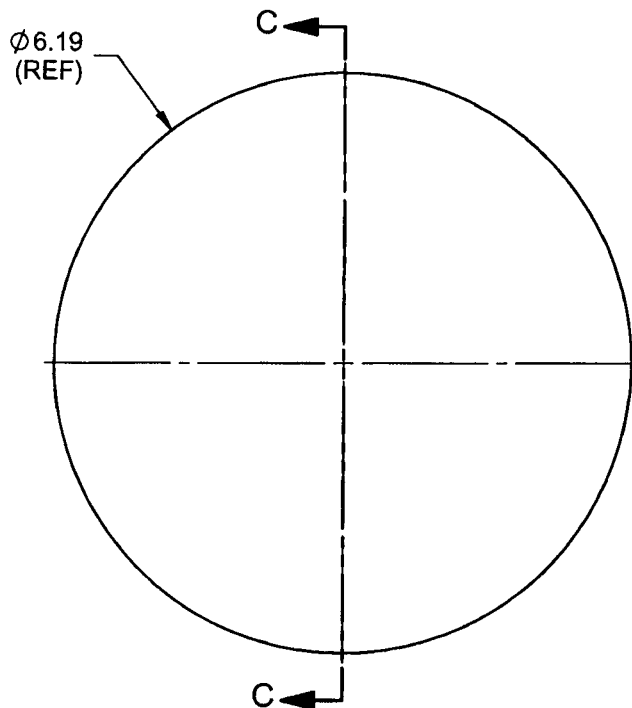
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED

06.04.03 *[Signature]***SECTION C-C**

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D3476-3S DOME, SPINNING DETAIL**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING
OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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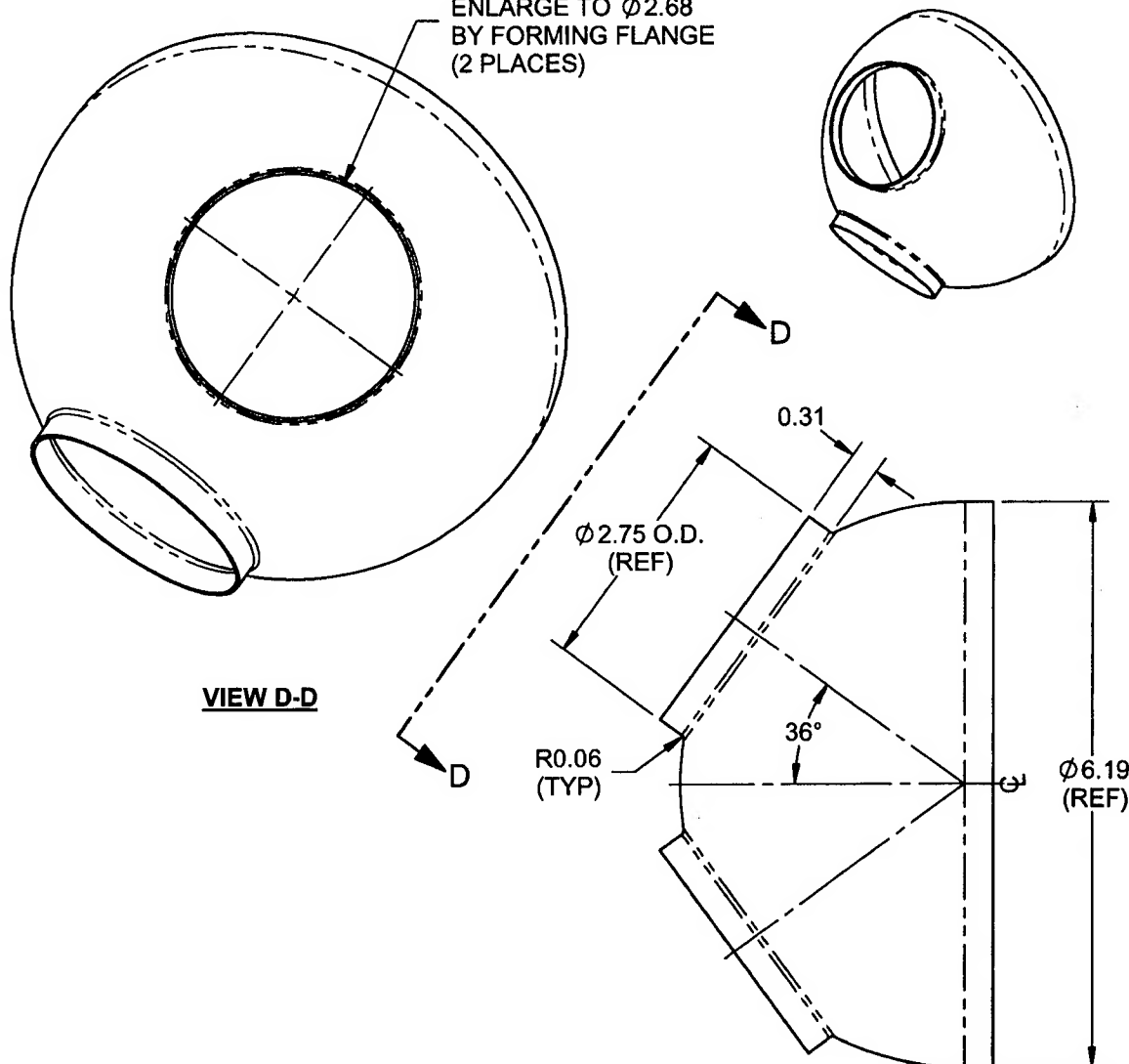
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

06.04.03

CUT $\phi 2.25$ HOLE,
ENLARGE TO $\phi 2.68$
BY FORMING FLANGE
(2 PLACES)

**D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

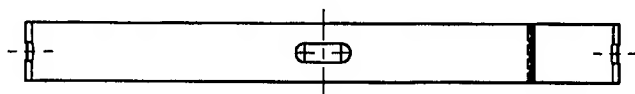
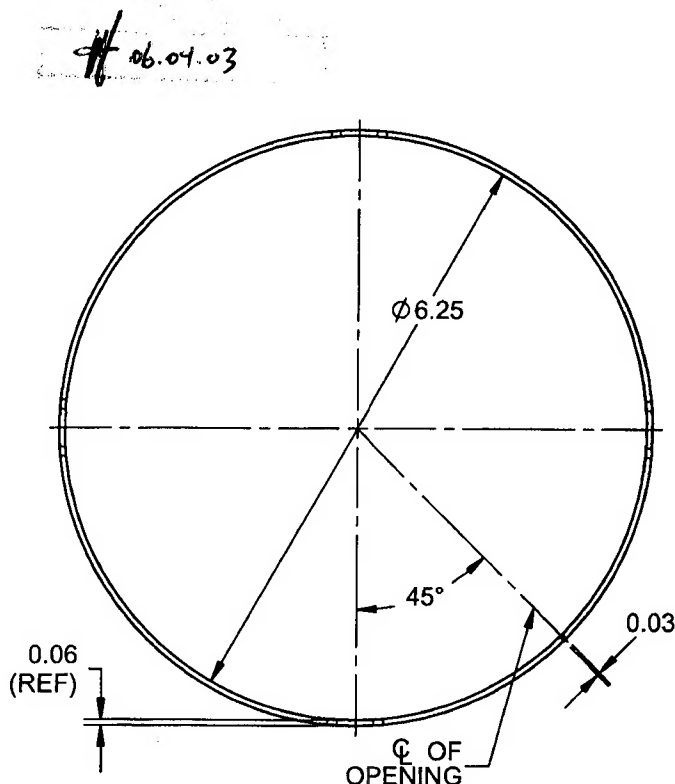
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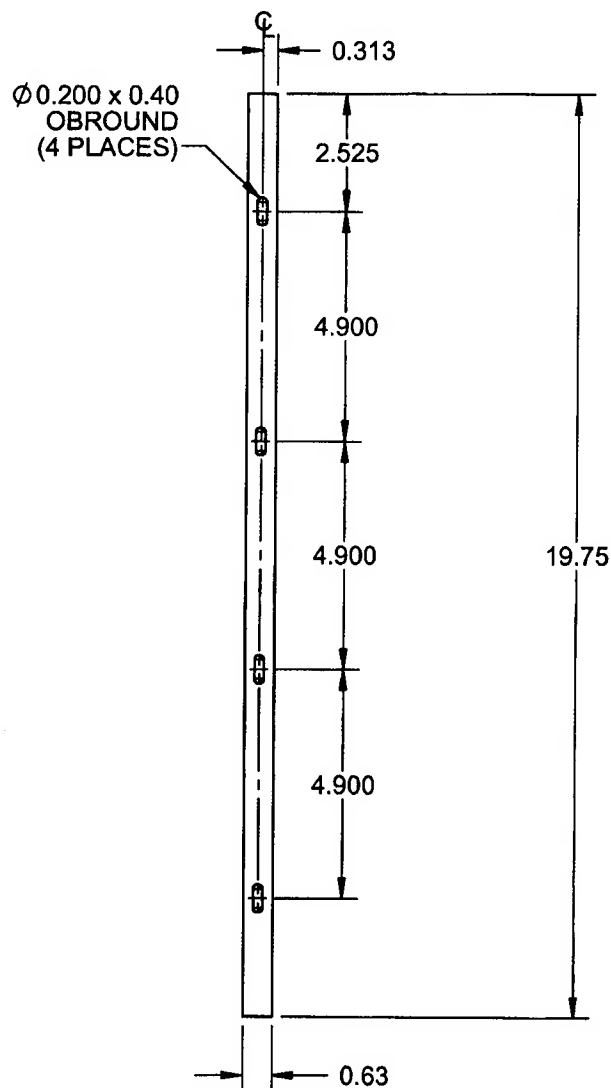
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	



D3476-5 SPACER-RING



**D3476-5F SPACER-RING
FLAT PATTERN**

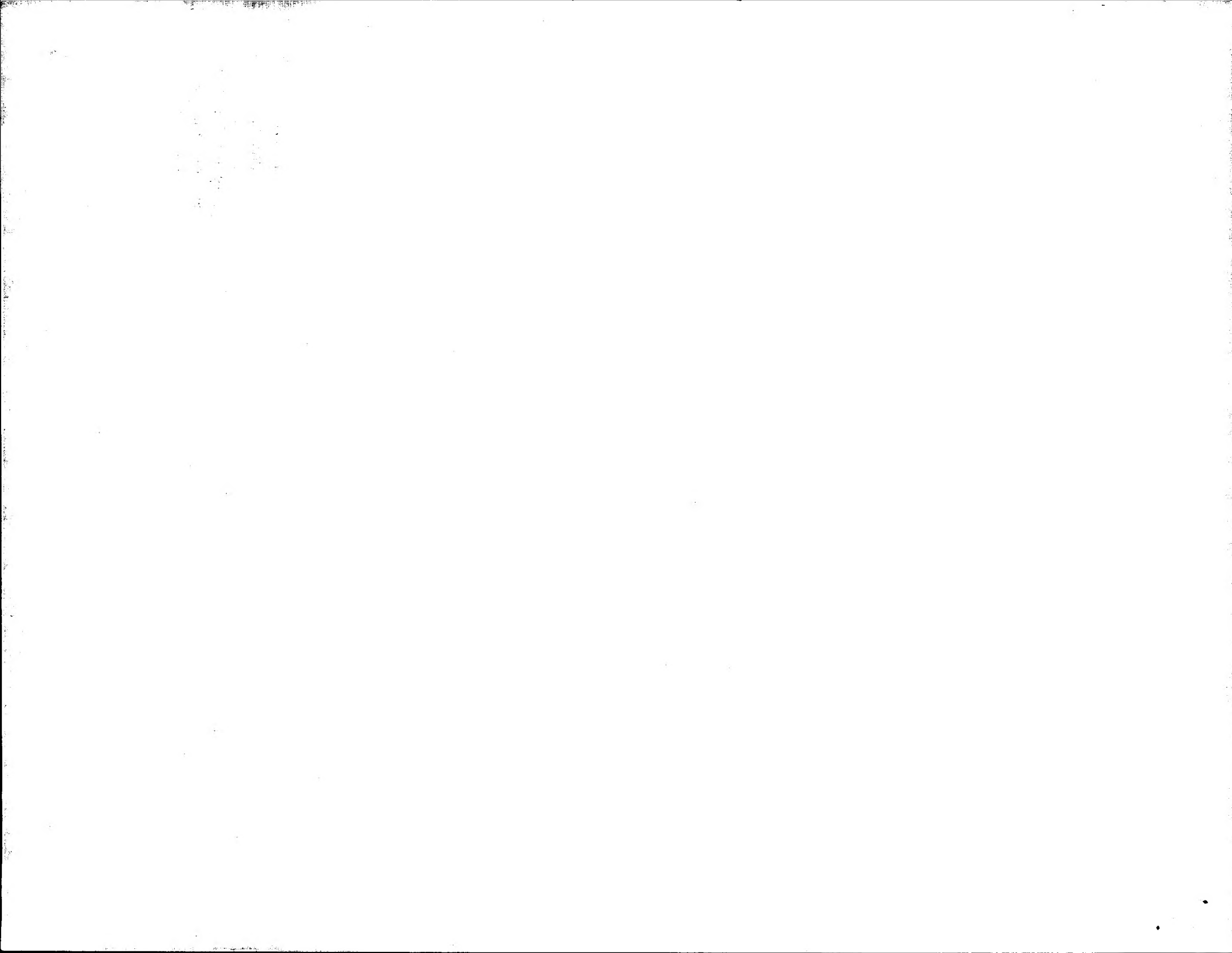
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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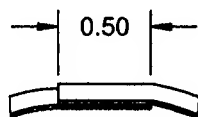
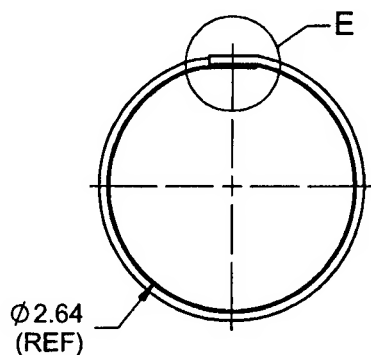
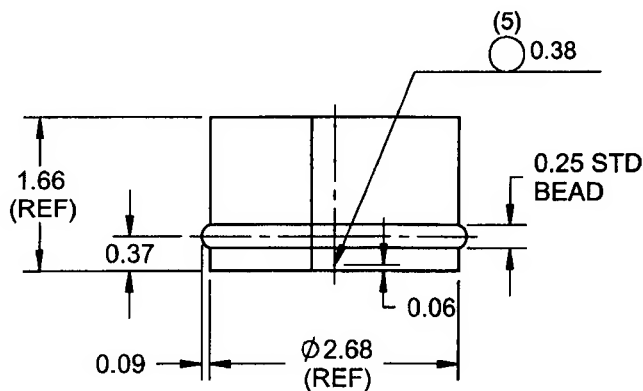
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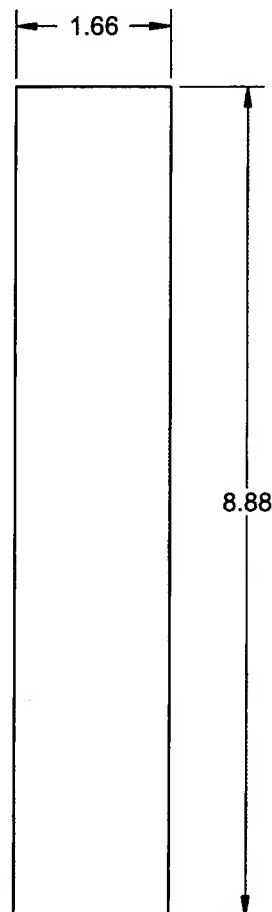


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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

[Handwritten] 06.04.03

DETAIL E
SCALE 1:1

D3476-7 TUBE**D3476-7 TUBE
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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